

Work Order ID 80233

Wednesday, February 15, 2012 11:47:58 AM

80233

Ship today

Page 1

Item ID: D206-559-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 2/15/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/15/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-02-15 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

8/12/02/15

JLH MLJ 12-2-15

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

SP 12-02-15

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

8/12/02/15

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Bearpaw

Start Date: 2/15/2012 Start Qty: 1.00 ***1***

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Required Date: 2/15/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location: _____

12/2/15

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/2/15

ME
12-02-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 80233

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 2/15/2012

Required Date: 2/15/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J04.02.17Blank size changedKJ/JLM

IPP Rev:K 07-01-02 Was K10008 JLM

IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC

IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified By:EC IPP Rev G

10.10.04 per DS19527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A Bolt		Purchased	No			160	Each	562.0000	12	12		118625	
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--------	--

Location	Loc Qty	Loc Code
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ST358	16	
116419	16	
116704	0	
ST359	546	
112314	8	
118983	300	
119798	8	
120187	230	

AN4-20A Bolt		Purchased	No			160	Each	577.0000	12	12			
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
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GA	76	
116419	76	
ST359	501	
104016	16	
117514	185	
118983	100	
119127	200	

AN960JD416 Washer	NAS1149D0463J	Purchased	No			160	Each	8.0000	24	24		119075	
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Location	Loc Qty	Loc Code
----------	---------	----------

ST351	8	
116289	8	

SP 12-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 80233

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 2/15/2012

Required Date: 2/15/2012

Start Qty: 1.00

Required Qty: 1.00

D2182B Manufactured No

Rubber Cushion

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

5 measured
size listed

Location

Loc Qty

Loc Code

ST410

450.88417

66063

41.61817

73932

409.266

160

f

450.8842

2.5

2.5

B73932

D2274 Manufactured No

Radius Block

Location

Loc Qty

Loc Code

ST007

331

78589

331

160

Each

331.0000

12

12

77037

D2432 Manufactured No

206 (24") Bearpaw

Location

Loc Qty

Loc Code

ST017

1

77862

1

160

Each

1.0000

2

2

78327

D2438 Manufactured No

Clamp

Location

Loc Qty

Loc Code

ST456

152

77038

34

78594

118

160

Each

152.0000

6

6

69737

D2529 Manufactured No

Washer

Location

Loc Qty

Loc Code

ST010

605

66953

2

79221

403

79485

200

12

12

76086

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Shop Packet Print

Page 2

SP 1202-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 80233

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 2/15/2012

Required Date: 2/15/2012

Start Qty: 1.00

Required Qty: 1.00

D2732 Manufactured No

160 f 231.3353 2.5

Rubber Extrusion

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

Location

Loc Qty

Loc Code

ST410

231.335299

70987

231.335299

MS21042L4 Purchased No

160 Each 5,335.0000 12 12

Nut

Location

Loc Qty

Loc Code

ST300

5335

117441

59

117601

157

118451

133

119017

200

119075

4786

SP 12-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	1/2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP